



# Service Repair Manual

## **Models**

**325B and 325B L EXCAVATOR**

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Product: EXCAVATOR

Model: 325B L EXCAVATOR 8RR

Configuration: 325B & 325B L TRACK-TYPE EXCAVATORS 8RR00001-UP (MACHINE) POWERED BY 3116 ENGINE

## Disassembly and Assembly 325B Excavator Machine Systems

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i02201834

## Final Drive - Assemble

SMCS - 4050-016

### Assembly procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-2420	Transmission Repair Stand	1
B	138-7573	Link Bracket	2
C	1P-1860	Retaining Ring Pliers	1
D	1U-5933	Seal Installer	1
E	138-7574	Link Bracket	2
F	5P-3931	Anti-Seize Compound	1
G	9S-3263	Thread Lock Compound	1
H	1U-8846	Gasket Sealant	1

**Note:** Make sure that all of the parts of the final drive are thoroughly clean and free of dirt and debris prior to assembly.

1. Check the condition of all the O-ring seals that are used in the final drive. If any of the O-ring seals are damaged, use new parts for replacement.

**Note:** If the final drive sprocket was removed from the main housing, refer to Disassembly and Assembly, "Final Drive Sprocket - Remove and Install" in this manual. Follow the installation procedure in order to install the final drive sprocket on the main housing.

2. Assemble the final drive on Tooling (A).

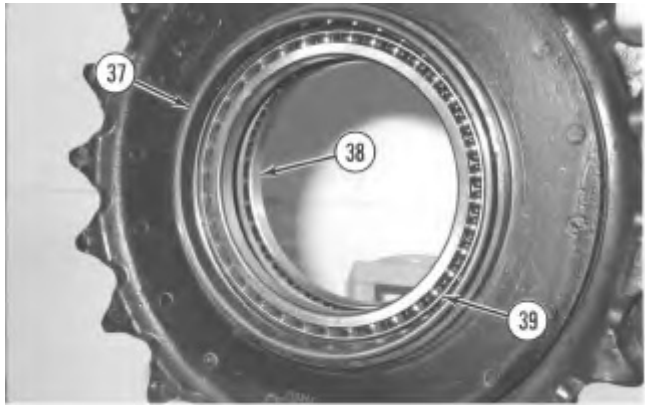


Illustration 1

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3. Apply Tooling (F) to the surfaces inside the main housing that contact bearings (38) and (39). Install bearings (38) and (39) in the original locations in the main housing with a press. Install bearings (38) and (39) until the bearings contact the counterbore in the main housing.



Illustration 2

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Illustration 3

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4. Use the following procedure to determine the correct bearing preload and the correct thickness of shims (35) that are used under gear (34).
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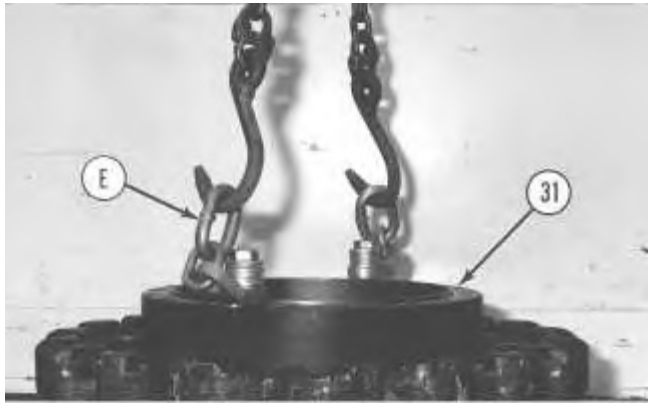


Illustration 4

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- a. Fasten Tooling (E) and a suitable lifting device to main housing (31), as shown. Install main housing (31) on the motor housing.
- b. Use a suitable press and a spacer to apply a load of 4000 kg (8820 lb) on bearing (38).
- c. Rotate the main housing in order to seat the bearings.
- d. Reduce the load on bearing (38) to  $1000 \pm 100$  kg ( $2200 \pm 220$  lb).



Illustration 5

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- e. Maintain the load on bearing (38). Measure the distance between the top face of the motor housing and the bearing inner race. Use a depth micrometer to take this measurement in several locations around the bearing. Compute the average of the measured dimensions and record the number. Call this dimension (Y).

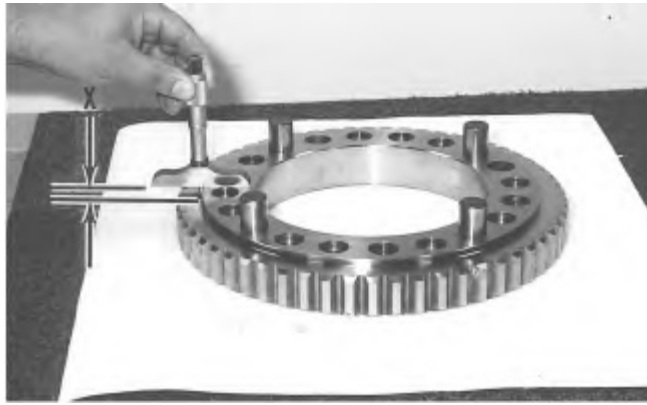


Illustration 6

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- f. Use a depth micrometer and measure the distance between the hub face and the gear face of gear (34). Take measurements at several locations around the gear. Compute the average of the measured dimensions and record the number. Call this dimension (X).
- g. Determine the correct thickness of the shim pack which is made up of shims (35). The shim pack is used between the motor housing and gear (34). Use the following equation to determine the shim pack thickness.

Shim pack thickness ...  $(X) - (Y) \pm 0.05 \text{ mm (0.002 inch)}$

**Note:** If two shims are required, install the thinner shim next to gear (34) when the gear is installed.

5. Remove the main housing from the motor housing.

**Note:** The rubber seals and all surfaces that contact the seals must be clean and dry. After installation of the seals, apply clean SAE 30 oil on the contact surfaces of the metal seals. For more information concerning the assembly and installation of Conventional Duo-Cone Seals, refer to Disassembly and Assembly, "Duo-Cone Conventional Seals - Install" in this manual.



Illustration 7

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6. Install Duo-Cone seal (37) in the main housing with Tooling (D).

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